



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703
Job Sheet 213719



Part No: 647.7703

Job Qty: 12 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/20

Job Tracking No:

Due Date: 10/30/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	12 pcs	10/16/20		0.00	4.74	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MW Oct 26/20
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
130	QC 9	12 pcs	10/16/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		DAS 50 / 10-27-20
							QC 9 - 9		
140	QC 5	12 pcs	10/16/20		0.00	0.00	QC 5 - 10		9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
E-mail: sales@dartaero.com
www.dartaerospace.com

Container No: S308603



Part: 647.7703

Job No: 213719

Serial No/Batch: S308603

Revision: Rev A2

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/26/20

Plex 10/1/20 3:14 PM Dart.Renwick.Jennifer

				QC 5 - 68	
				QC 5 - 9	DAS
				QC 5 - 50	50 NOV 27 20
				QC 5 - 30	89
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150	Outsource - 3 - Cadplate	12 pcs	10/29/20	GRO002-VC	10 OCT 28 2020
160	Packaging 2-1 - Receive - B4B	12 pcs	10/29/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
					Packaging 2 - 37 - B4B
170	QC 6	12 pcs	10/29/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
180	Spray Paint - 2 - B4B	12 pcs	10/30/20	0.00 0.69	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
190	QC 14	12 pcs	10/30/20	0.00 0.00	QC 14 - 15
					QC 14 - 2

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				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	DAS 81
				QC 14 - 82	9-89
				QC 14 - 87	
				QC 14 - 47	
200	Packaging 3-1 - Stock - B4B	12 pcs	10/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
210	QC 21 - SA	12 pcs	10/30/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

DAS
81
9-89

NOV 04 2020

DAS
28
9-89

NOV 04 2020

DAS
28
9-89

NOV 04 2020

Part Op 120 - Weld per dwg A/R 4130 rod Batch 1127925 - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT

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Descriptions: DIMENSION IS 8.35" ***

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II *****NOTE: limite cad platting on thread to 0.003" or less****

160 - Receive & Inspect for Damage & Mat'l Certs

170 - INSPECT USING GO/NO GO GAUGE

180 - Spray Paint / NDT Room - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG *5 267778*

190 - QC14- Inspect Spray Paint

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	12 pcs (1 ea)	120-Large Fab - Welded Assy-1	<i>17 5256207 / 5303179</i>
647.7713	Strut Thread	12 pcs (1 ea)	120-Large Fab - Welded Assy-1	<i>18 5303187 / 5296196</i>
647.7714	Strut Tube	12 pcs (1 ea)	120-Large Fab - Welded Assy-1	<i>5253115</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7712	12	23	0
	647.7713	12	20	0
	647.7714	12	23	0

Part Specifications

Specifications could not be found.

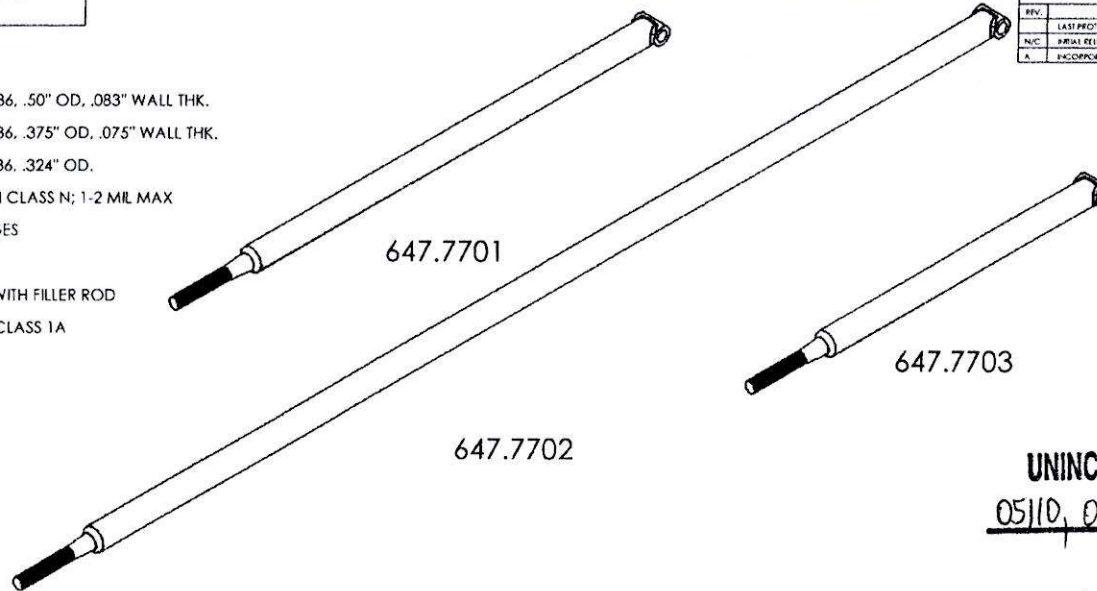
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1. THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

NOTES:

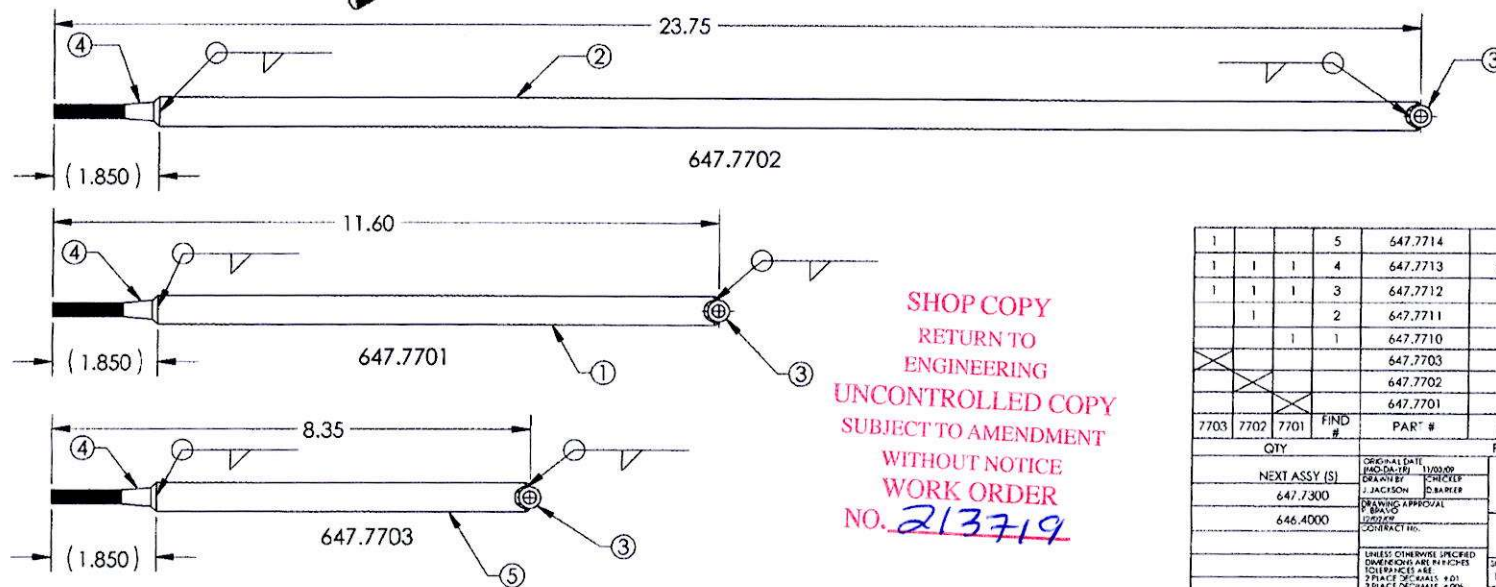
1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337 J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION REQ		
2	INITIAL RELEASE	12/02/98	P. BRAVO
3	UNINCORPORATED ECN 04141	11/13/14	P. BRAVO



UNINCORPORATED ECN(s)

05110, 05397,



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213719

1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
		1	2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	PAR #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE 11/03/00			
647.7300				DRAWN BY J. JACKSON			
646.4000				CHECKED D. BARBER			
				DRAWING APPROVAL P. BRAVO			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS IN INCHES			
				TOLERANCES ARE			
				2 PLACE DECIMALS ±.01			
				3 PLACE DECIMALS ±.005			
				ANGLES ±.5°			
				DATE 07/14/16			
				SCALE NONE			
				SHEET 1 OF 2			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

STRUT ASSY

647.7700

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB047469**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047469

PO Date: 10/28/20

Due Date: 10/30/20

Purchase Order

Revision:

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	213719	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad plating on thread to 0.003" or less****	Firmed - X12		10/30/20	12 pcs	0 pcs	12 pcs	\$21.9209/pcs	\$263.05
NOV 02 2020												
Line Item Note: ***** RUSH *****												
Grand Total:											\$263.05	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

Plex 10/28/20 12:22 PM dart.lussier.patrick



Certificat de Conformité / Certificate of Compliance

(031847-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

031847 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
30-Oct-2020	SPARTAKOS BOUNTOURIS		POHB047469					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7703 Rev.A2	647.7700 01 -CAD YELLOW 0.0005 THICK OR LESS CAD PLATE IAW QQ-P-416F CLASS I TYPEII THICKNESS 0.0005" CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD MATERIAL STEEL LIMITE ON THREAD 0.0003" MAX OR LESS	CADMIUM CH	12	12	0	0	0

DAS
40
9-89

RECEIVED

NOV 02 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

CM

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jessie

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.